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D3914-041
Job Sheet 197013



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/27/19

Job Tracking No:

Due Date: 7/20/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	7/20/19		0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		CL
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	1 pcs	7/20/19		0.00	0.00	Large Fab - 11 (Various)		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		DAS 43 9-89
							QC 9 - 50		
120	QC 5	1 pcs	7/20/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		DAS 43 9-89
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		

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						QC 5 - 68		
						QC 5 - 9		
						QC 5 - 50		
						QC 5 - 30		
						QC 5 - 40		
130 Powdercoat - 4 Black Sand - B4B <i>M138940.</i>	1 pcs	7/20/19	0.00	0.40		Powdercoat - 1 - B4B		
						Powdercoat - 2 - B4B		
						Powdercoat - 3 - B4B	<i>3/19 9-10.</i>	
						Powdercoat - 4 - B4B		
<i>START: 10:25 A.T. 3:00 FINISH: 10:55</i> 135 QC 3	1 pcs	7/20/19	0.00	0.00		QC 3 - 10		
						QC 3 - 13		
						QC 3 - 15	<i>HL 14-9-10</i>	
						QC 3 - 17		
						QC 3 - 18		
						QC 3 - 2		
						QC 3 - 28		
						QC 3 - 3		
						QC 3 - 30		
						QC 3 - 34		
						QC 3 - 36		
						QC 3 - 41		
						QC 3 - 51		
						QC 3 - 58		
						QC 3 - 59		
						QC 3 - 68		
						QC 3 - 9		
						QC 3 - 40		
						QC 3 - 19		
						QC 3 - 43		
						QC 3 - 24		
						QC 3 - 61		
						QC 3 - 81		
140 Handfinish - 3-1- WingWalk- B4B	1 pcs	7/20/19	0.00	0.80		Handfinish - 3 - 1 - B4B	<i>HL 14-9-10</i>	
						Handfinish - 3 - 2 - B4B		
						Handfinish - 3 - 3 - B4B		
						Handfinish - 3 - 4 - B4B		
						Handfinish - 3 - 5 - B4B		
150 QC 3	1 pcs	7/20/19	0.00	0.00		QC 3 - 10		
						QC 3 - 13		
						QC 3 - 15		
						QC 3 - 17		
						QC 3 - 18		
						QC 3 - 2		
						QC 3 - 28		
						QC 3 - 3		
						QC 3 - 30		
						QC 3 - 34		
						QC 3 - 36		
						QC 3 - 41		
						QC 3 - 51	<i>DAS</i>	<i>SEP 10 2019</i>
						QC 3 - 58	<i>81</i>	
						QC 3 - 59	<i>9-89</i>	
						QC 3 - 68		
						QC 3 - 9		
						QC 3 - 40		
						<i>Plex 6/27/19 8:49 AM Dart.Guerin.Kimberley</i>		

160 Packaging 3-1 - Stock - B4B	1 pcs	7/20/19	0.00	0.00	QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	MU 19-4-10
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	

				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	1	7/20/19	0.00 0.00	QC 21 - SA - 21	
	pcs			QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____ - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5188852
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5189585
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5147279
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	5183147
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	5144434
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	5182801
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5181242
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	5147477

208015

Master Unit: 011457

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	58	0
	D3914-1	2	12	0
	D3914-7	2	14	0
	D4016-3	3	92	0
	D4018-5	9	46	0
	D4020-5	1	7	0
	D4021-3	1	34	0
	D4035-043	2	24	0

Part Specifications

Specifications could not be found.

D4020-5 not allocated, Missing Qcd on new batch

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